

Date: Monday, 9/11/2006 3:45:22 PM  
User: Kim Johnston

*Split*  
SB 06/12/04

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GAS SPRING
Job Number	: 28488-1	Part Number	: D2807
Estimate Number	: 10336	Drawing Number	: D2807 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/11/2006	Drawing Revision	: C
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 9/30/2006
Previous Run	: 27562	Qty:	40
Written By	: <i>[Signature]</i>	Um:	Each
Checked & Approved By	: <i>[Signature]</i> 06.09.12		
Comment	Est: D 05.96.21 Removed painting; Changed supplier KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING 
		<i>C 06/10/12 40</i>
		<i>Comment: PURCHASING Issue P/O: 2009 Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required</i>
2.0	SXF6S6050080S6L115N	GAS SPRING 
		<i>Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s) SUPPORT PROP</i>
3.0	PACKAGING 1	PACKAGING RESOURCE #1 
		<i>Comment: PACKAGING RESOURCE #1 Receive &amp; Inspect for Transit Damage Ensure Material Release Note is attached</i>
4.0	QC6	DIMENSIONAL CHECK 
		<i>J06.10.10 40</i>
		<i>Comment: DIMENSIONAL CHECK</i>
5.0	D28073	Lug 
		<i>Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s) Pick: 2 D2807-3 Lug Batch: B26647 45 35</i>
		<i>SB 06/10/04 40</i>

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING

Job Number: 28488

Part Number: D2807

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



(P) →  
last pg  
(H)

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

- 1-Install lugs and crimp using DT8791 crimp jig.
- 2-Remove lettering and logo with wash and wipe.

SB 06/12/04 (4)

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

C 06/12/04 (4)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



(4)

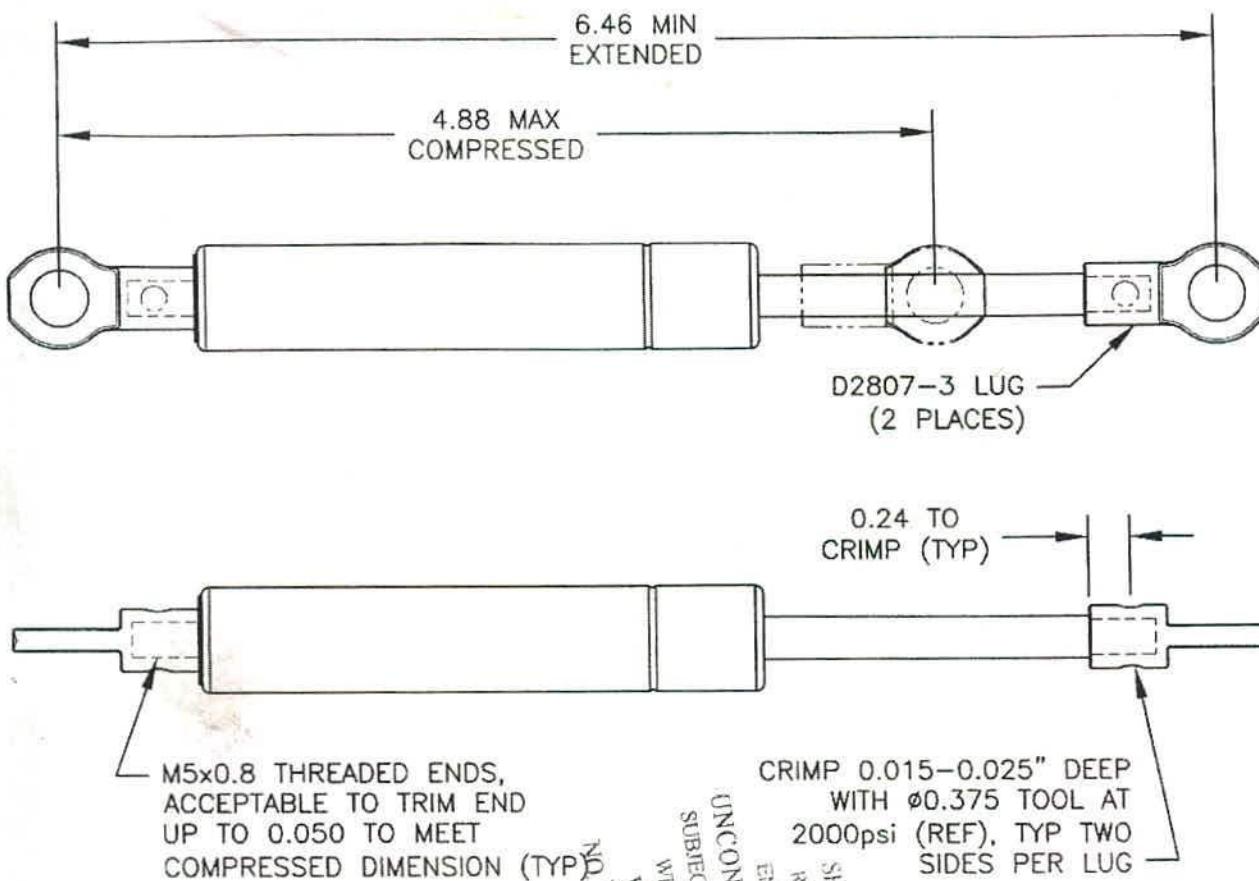
Comment: FINAL INSPECTION/W/O RELEASE

SP06/12/04

Job Completion



C 06/12/04



### D2807 GAS SPRING

1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF656050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
[Signature]

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		DRAWING NO. D2807
DATE 05.05.25		SHEET 1 OF 2
		SCALE 1:1
A	00.11.03	TITLE GAS SPRING
B	05.03.16	
C	05.05.25	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/12/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/04	60	1x 02807 is scrapped due to gauges on the shaft. cause is unknown. 2x 02807-3 were installed, and crimped.	<u>B</u> <u>06/12/04</u>	destroy & replace.	<u>Z</u> <u>06/12/04</u>	<u>M</u> <u>06/12/04</u>	<u>B</u> <u>Closed</u>	<u>M</u> <u>06/12/04</u>

NOTE: Date & initial all entries